

# Work Order ID 58936

May 26, 2010 10:20:06 AM



Page 1

Item ID: D205-596-107

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft Extended



Start Date: 5/20/10 Start Qty: 1.00

Cust Item ID:

Required Date: 6/07/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|          |              |  |
|----------|--------------|--|
| Draw Nbr | Revision Nbr |  |
|----------|--------------|--|

|          |       |  |
|----------|-------|--|
| D205-596 | Rev B |  |
|----------|-------|--|

100



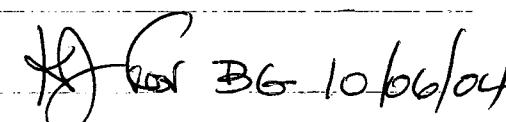
DOCUMENT CONTROL

DC

Document Control

Memo

Photocopy D205-594 bluefile & type labels per PPP D205-596-107 CHG002

  
BG 10/06/04

5/10/04

110



BENDING MACHINE - CROSSTUBES

CNC Bend 2

CNC Alpha 160 Bender

Memo

Bend as per Dwg D2890 using CNC bender program

  
MB 10-05-26

120



Crosstubes

Crosstubes

Memo

Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

  
MA 10.05.26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 58936**

May 26, 2010 10:20:07 AM



Page 3

Item ID: D205-596-107

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft Extended

Cust Item ID:

Start Date: 5/20/10 Start Qty: 1.00

Customer:



Required Date: 6/07/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

**Sequence ID/  
Work Center ID**

160



HandFXtube

**Operation  
Description**

Crosstubes Chemical Conversion

HandFinishing

Hand Finishing Crosstubes

170



QC

Quality Control

QC3- Inspect Part Finish

Memo

180



SprayPaint

SprayPaint

Memo

Spray Painting

1-Prime inside and outside with Immron per QSI 005 4.2

**Set Up/  
Run Hours**

0.00

**Tool ID**

0.00

**Tool #**

0.00

**Plan  
Code**

0.00

**Accept  
Qty**

0.00

**Reject  
Qty**

0.00

**Reject  
Number**

0.00

**Insp.  
Stamp***1 - ~ AW 10-5-08**S10lost31**60**M 10 06 01 0*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 58936**

May 26, 2010 10:20:07 AM



Page 4

Item ID: D205-596-107

Accept



Setup Start



Revision ID:

Item Name: Crosstube Aft Extended

Stop



Start Date: 5/20/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/07/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

190

QC14- Inspect Spray Paint



QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

85

10-06-02

(1)

200



Crosstubes

Crosstubes

0.00

ml 10 06 02 (1)

Crosstubes

Memo

0.00

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area  
with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-107 Magnobond 6398

Batch: 114021 EXP: 01/2011

3-Inst

Torque: M 10-06-03 (1)

210



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

S 10-06-03

(1) \_\_\_\_\_

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 58936**

May 26, 2010 10:20:07 AM



Page 5

Item ID: D205-596-107

Accept



Setup Start



Revision ID:

Item Name: Crosstube Aft Extended

Stop



Start Date: 5/20/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/07/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

220

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Packaging

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D205-596-107

Location:       PPP Rev:       

230



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

May 26, 2010 10:20:05 AM

Page 1

Work Order ID: 58936



Parent Item: D205-596-107



Parent Item Name: Crosstube Aft Extended

Start Date: 5/20/10

Required Date: 6/07/10

Comments: IPP Rev:D 05.03.21 Added bending procedure KJ/JLM

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:E 08-01-10 ECN 1075

DD

IPP Rev F 08.04.28 Added bending & mat'l

EC

verified by: DD

| Component Item ID/ | Replacement | Mfg/<br>Manufactured | Bin | Primary<br>No | Last | Route<br>200 | Unit of<br>Each | Qty on<br>45.0000 | Qty per Kit<br>2 | Total<br>2 | Qty | Date | Status |
|--------------------|-------------|----------------------|-----|---------------|------|--------------|-----------------|-------------------|------------------|------------|-----|------|--------|
| D2940-1            |             |                      |     |               |      |              |                 |                   |                  |            |     |      |        |



Support

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| LG           | 45      |          |
| 45203        | 1       |          |
| 47748        | 16      |          |
| <u>52752</u> | 8       |          |
| 57338        | 20      |          |

W/ 10-06-02

D6008-180



Manufactured No

Crosstube Extrusion

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG       | 11      |          |
| 46779    | 11      |          |

WB 10-06-02

MS21920-28

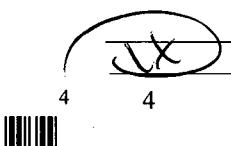


Purchased No

Clamp(per MIL-DTL-8783C)

| Location      | Loc Qty | Loc Code |
|---------------|---------|----------|
| FG            | 5       |          |
| 105884        | 5       |          |
| LG            | 146     |          |
| 112624        | 2       |          |
| <u>112863</u> | 42      |          |
| 113776        | 2       |          |
| 114749        | 100     |          |

W/ 10-06-02



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

Page 2

May 26, 2010 10:20:05 AM

Work Order ID: 58936



Parent Item: D205-596-107



Parent Item Name: Crosstube Aft Extended

Start Date: 5/20/10

Required Date: 6/07/10

Comments: IPP Rev:D 05.03.21 □ Added bending procedure □ KJ/JLM

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:E 08-01-10 ECN 1075

DD

IPP Rev F 08.04.28 Added bending & mat'l

EC

verified by: DD

| Component Item ID/ | Replacement | Mfg/<br>Manufactured | Bin | Primary<br>No | Last | Route<br>200 | Unit of<br>Each | Qty on<br>96.0000 | Qty per Kit<br>4 | Total<br>4 | Qty | Date | Status |
|--------------------|-------------|----------------------|-----|---------------|------|--------------|-----------------|-------------------|------------------|------------|-----|------|--------|
| D3595-063-530      |             |                      |     |               |      |              |                 |                   |                  |            |     |      |        |

RUBBER CUSHION

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP           | 96      |          |
| 50030        | 20      |          |
| <u>51776</u> | 76      |          |

ML 10-06-02

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

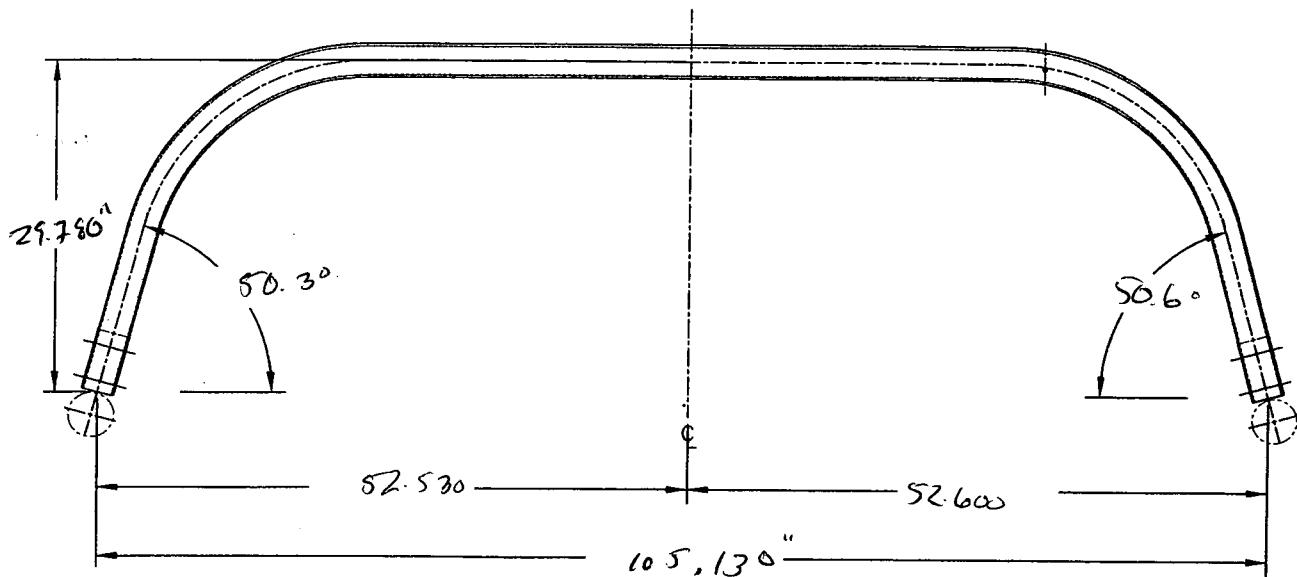
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                                      |              |              |
|--------------------------------------|--------------|--------------|
| DART AEROSPACE LTD                   | Work Order:  | 58936        |
| Description: Crosstube High-High Aft | Part Number: | D205-596-107 |
| Inspection Dwg: D205-596-107         | Rev: B       | Page 1 of 1  |

| Required Dimension | Min   | Max   |
|--------------------|-------|-------|
| Height             | 29.7  | 29.9  |
| 1/2 Span           | 52.4  | 52.6  |
| Angle              | 49    | 52    |
| Total Span         | 104.8 | 105.2 |



| Comments                   |
|----------------------------|
| * Mark cut line at 29.780" |
|                            |
|                            |
|                            |

|                 |         |      |
|-----------------|---------|------|
| QC15 Inspection | S       | 5/20 |
| Date            | 10/1/21 |      |

| Rev | Date     | Change          | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A   | 07.02.06 | New Issue       | KJ/JM      |          |
| B   | 08.04.21 | Dwg Rev updated | KJ/JM      | JM       |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

PARTS LIST:

| Qty | Part Number    | Description   |
|-----|----------------|---|
| X   | D205-596-107   | CROSSTUBE ASSEMLBY, HI-HI AFT   |
| 1   | D6008-180      | CROSSTUBE   |
| 2   | D2940-1        | SUPPORT   |
| 4   | D3595-063-530  | RUBBER CUSHION  |
| 4   | MS21920-28     | CLAMP   |
| A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE<br>(TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2<br>ADHESIVE) |

GENERAL NOTES:

1) MATERIAL: MANUFACTURE FROM D6008-180  
FINISHED LENGTH =  $127.28 \pm 0.02$

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS

7) WEIGHT: 50 lbs

8) PART IS SYMMETRIC ABOUT CENTERLINE

9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.

10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.

NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER MS21920-XX CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.

13) TORQUE CLAMPS 80 TO 100 IN-LB

DEO ATTACHED

RE-DL. 10/10/03

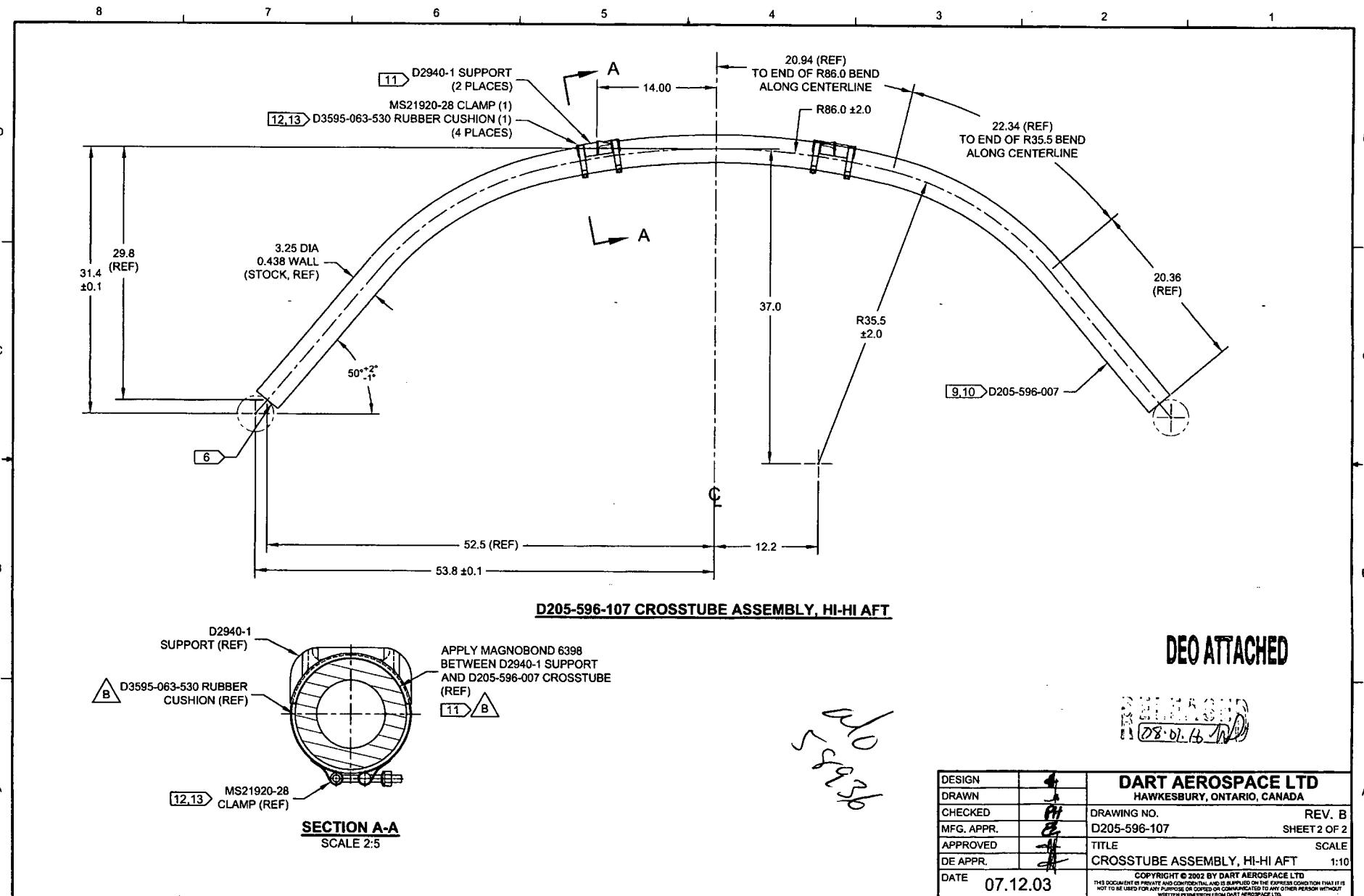
|            |   |   |              |          |
|------------|---|---|--------------|----------|
| B          | SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION |   | MB           | 07.12.03 |
| A          | NEW ISSUE   |   | DS           | 02.11.20 |
| REV.       | DESCRIPTION   |   | BY           | DATE     |
| DESIGN     | 4   | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA   |              |          |
| DRAWN      | 4   |   |              |          |
| CHECKED    | PH  | DRAWING NO.   | REV. B       |          |
| MFG. APPR. | EZ  | D205-596-107  | SHEET 1 OF 2 |          |
| APPROVED   | SH  | TITLE   | SCALE        |          |
| DE APPR.   | SH  | CROSSTUBE ASSEMBLY, HI-HI AFT   | NTS          |          |
| DATE       | 07.12.03  | COPRIGHT © 2002 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

| DRAWING NO.<br>D205-596-107 | TITLE<br>CROSSTUBE | REV. B               | DART AEROSPACE LTD<br>ENGINEERING ORDER | D.E.O. NO.<br>D205-596-107-B-1 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
|-----------------------------|--------------------|----------------------|---|--------------------------------|---------------------------|--------------|
| DRAWN <i>10</i>             | CHECKED <i>PS</i>  | MFG. APPR. <i>EC</i> | APPROVED <i>AM</i>                      | DE APPR. <i>MF</i>             |                           |              |
| DATE 09.05.01               | DATE 09.05.15      | DATE 09.06.15        | DATE 09.06.15                           | DATE 09.06.16                  | DATE 09.06.16             |              |

**CHANGE:**

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

| Part Number   | Description                        |
|---------------|------------------------------------|
| D205-596-107B | CROSSTUBE ASSEMBLY (214 HI-HI AFT) |

THE D205-596-107B CROSSTUBE HAS THE SAME PARTS LIST AS THE D205-596-107 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D205-596-107 CROSSTUBE.

**RELEASED**  
*09/06/22 MF*

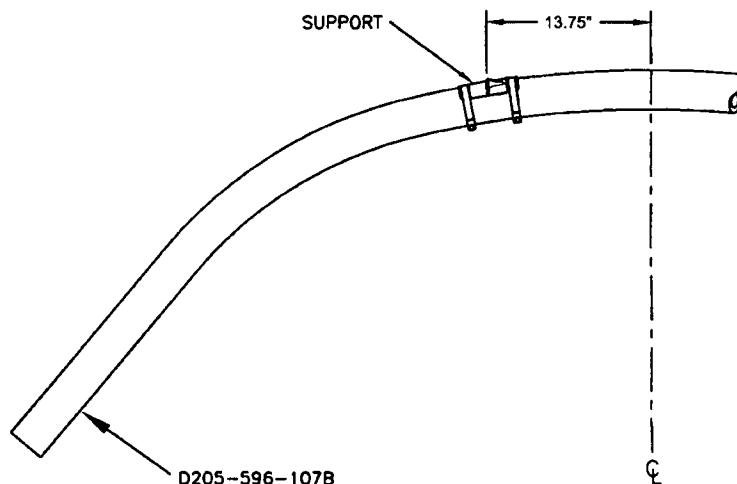


FIGURE 1 - SUPPORT INSTALLATION